





# Work Order ID 52905

October 19, 2009 12:38:27 PM



Item ID: D2574

Accept



Setup Start



Revision ID: E

Stop



Item Name: Saddle, Aft In 205

Start Date: 10/19/09 Start Qty: 12.00



Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00	M.A 09/10/26			12	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00	PR 02 10-27			12			
150  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo START TIME: 11:00AM FINISH TIME: 11:30AM	0.00  0.00	M112260 7 JH 09/10/22			(X)12	0		
				OVEN TEMPERATURE: 320°F					



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Page 3

Item ID: D2574  
Revision ID: E  
Item Name: Saddle, Aft In 205

Accept

Setup Start

Stop

Start Date: 10/19/09 Start Qty: 12.00  
Required Date: 11/02/09 Req'd Qty: 12.00

Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

09-10-27

12

170 Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

Packaging

Memo

0.00

Packaging

09/10/28

180 QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09-10-28



# Picklist Print

October 19, 2009 12:38:32 PM

Page 1 ✓

Work Order ID: 52905

Parent Item: D2574RevE

Parent Item Name: Saddle, Aft In 205

Comments:

Start Date: 10/19/09

Required Date: 11/02/09

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-005RevB	A	Manufactured	No			110	Each	0.0000	12.0000			



Saddle Billet



646411 x 12 SK 09/10/22







WITH  
WORK

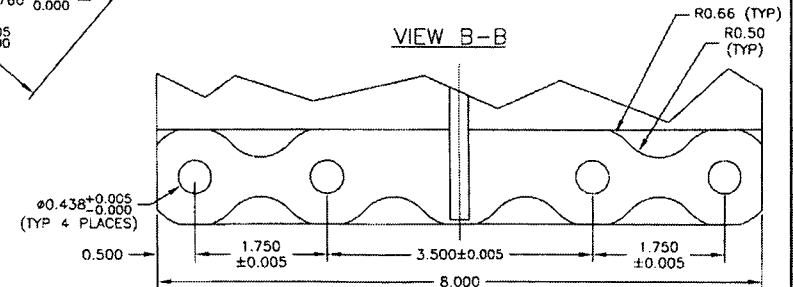
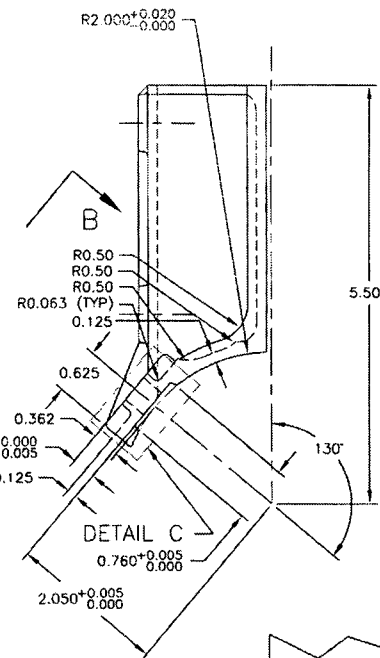
PM 09-10-K

RELEASED

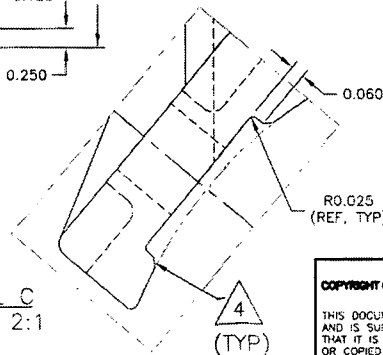
05.2.06


MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- |   |  |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)      |
|  | CHAMFER 0.063 x 45° ALL AROUND                                   |
|  | CHAMFER 0.033 x 45° (SEE DETAIL C)                               |



DETAIL C  
SCALE 2:1



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCRP. DEC 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN		 <b>DART AEROSPACE LTD.</b> HAINESBURY, ONTARIO, CANADA
DS	DRAWN BY PH	
CHECKED	APPROVED	DRAWING NO. D2574
DATE	05.07.13	TITLE INNER AFT SADDLE
		SCALE 2:3



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	52905
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b>	D2574
<b>Inspection Dwg:</b> D2574 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.441	.440	.439	.440		
B	1.745	1.755		1.750	1.750	1.749	1.749		
C	3.495	3.505		3.500	3.500	3.499	3.499		
D	1.745	1.755		1.750	1.750	1.749	1.749		
E	7.990	8.010		8.000	8.002	8.002	8.002		
F	0.490	0.510		.497	.509	.504	.504		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.502	.501	.502	.501		
J	1.174	1.184		1.180	1.178	1.177	1.177		
K	0.558	0.578		.574	.568	.569	.569		
L	1.174	1.184		1.180	1.178	1.177	1.177		
M	1.365	1.375		1.370	1.369	1.369	1.369		
N	2.495	2.505		2.500	2.499	2.499	2.499		
O	4.119	4.129		4.124	4.122	4.123	4.123		
P	0.115	0.135		.127	.126	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.253	.250	.251	.250		
S	0.115	0.135		.125	.122	.135	.134		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.231	3.229	3.230	3.230		
V	0.230	0.250		.234	.230	.240	.237		
W	0.115	0.135		.128	.129	.128	.126		
X	0.307	0.312		.311	.312	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.367	.361	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.630	.628	.629		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.240	.249	.246		
AE	1.500	1.520		1.510	1.517	1.510	1.510		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.275	.273	.275		
AH	0.240	0.260		.247	.242	.250	.249		
AI	2.000	2.020		2.004	2.008	2.000	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	SP
Date:	09/10/23

Audited by:	N.A
Date:	09/10/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	52905
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b>	D2574
<b>Inspection Dwg:</b> D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	26	37	48		
A	0.438	0.443		.440	.439	.440	.440		
B	1.745	1.755		1.750	1.749	1.750	1.749		
C	3.495	3.505		3.500	3.499	3.500	3.499		
D	1.745	1.755		1.750	1.749	1.750	1.749		
E	7.990	8.010		8.002	8.002	8.002	8.002		
F	0.490	0.510		.506	.505	.505	.502		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.501	.501	.502		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		.568	.569	.569	.570		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.365	1.375		1.368	1.368	1.369	1.369		
N	2.495	2.505		2.499	2.499	2.499	2.499		
O	4.119	4.129		4.122	4.122	4.122	4.123		
P	0.115	0.135		.124	.123	.124	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.249	.250	.251	.251		
S	0.115	0.135		.131	.131	.132	.131		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.228	3.228	3.228	3.228		
V	0.230	0.250		.236	.236	.236	.237		
W	0.115	0.135		.128	.129	.129	.128		
X	0.307	0.312		.312	.312	.312	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.363	.364	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.627	.629	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.243	.244	.244	.244		
AE	1.500	1.520		1.512	1.512	1.512	1.512		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.270	.271	.274	.275		
AH	0.240	0.260		.246	.246	.246	.247		
AI	2.000	2.020		2.003	2.004	2.005	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	OMF
Date:	09/10/25

Audited by:	H.A
Date:	09/10/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



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<b>Inspection Dwg:</b> D2574 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				#9	#10	#11	#12		
A	0.438	0.443		.439	.439	.440	.440		
B	1.745	1.755		1.749	1.749	1.750	1.749		
C	3.495	3.505		3.506	3.499	3.506	3.500		
D	1.745	1.755		1.749	1.749	1.750	1.749		
E	7.990	8.010		8.000	8.002	8.002	8.002		
F	0.490	0.510		.508	.507	.504	.504		
G	0.257	0.262		.259	.259	.259	.260		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.502	.502	.501	.502		
J	1.174	1.184		1.177	1.177	1.178	1.178		
K	0.558	0.578		.569	.569	.568	.569		
L	1.174	1.184		1.177	1.177	1.177	1.178		
M	1.365	1.375		1.368	1.369	1.369	1.376		
N	2.495	2.505		2.499	2.499	2.499	2.499		
O	4.119	4.129		4.122	4.122	4.123	4.124		
P	0.115	0.135		.126	.126	.128	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.257	.250	.253	.257		
S	0.115	0.135		.133	.133	.134	.132		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.228	3.228	3.228	3.229		
V	0.230	0.250		.238	.237	.237	.236		
W	0.115	0.135		.126	.126	.125	.127		
X	0.307	0.312		.312	.312	.311	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.361	.362	.361	.362		
AA	0.470	0.530		.500	.500	.500	.506		
AB	0.615	0.635		.626	.629	.629	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.243	.243	.243		
AE	1.500	1.520		1.512	1.512	1.515	1.513		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.270	.271	.271	.271		
AH	0.240	0.260		.248	.247	.245	.246		
AI	2.000	2.020		2.003	2.003	2.006	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	anf
Date:	09/10/26

Audited by:	H.A
Date:	09/10/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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